

Work Order ID 165329***165329***

Page 1

Monday, August 21, 2017 2:03:21 PM

Item ID: D5149-7TRN

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Aft Step Base Turning Detail

Start Date: 8/30/2017 Start Qty: 4.00

4

Cust Item ID:

Required Date: 9/6/2017 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

DASDate: AUG 22 2017

Tooling:

Date:

Run Start

NR1

QC:

21

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D5149

D

100

0.00

100

MORI SEIKI CNC LATHE LARGE

Doosan

Memo

1.51

Doosan Lathe

Turn blank as per Folio FB356

DAS
339-8917/02/24

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.04

Quality Control

DAS
339-8917/02/24

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.08

Quality Control

DAS
449-8917-08-28

Work Order ID 165329

Monday, August 21, 2017 2:03:21 PM

165329

Page 2

Item ID: D5149-7TRN

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Aft Step Base Turning Detail

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Cust Item ID:

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4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							DAS 44 9-89
130	Packaging					S	Ø		17-08-28
Packaging	Memo	0.04							
Packaging	LOCATION: MAT060								
140	QC21 - Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.40							
Quality Control									

DAS
21
9-89
AUG 21 2017

Picklist Print

Monday, August 21, 2017 2:03:24 PM

Page 1

Work Order ID: 165329

165329

Parent Item: D5149-7TRN

D5149-7TRN

Parent Item Name: Aft Step Base Turning Detail

Start Date: 8/30/2017

Required Date: 9/6/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 14-12-08 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6R3.250

Purchased

No

100

f

7.7250

0.416

1.664

DAS

33

9-89

M6061T6R3 250

**

6061-T6 RD BAR 3.250"

17/08/24

Location

Loc Qty

Loc Code

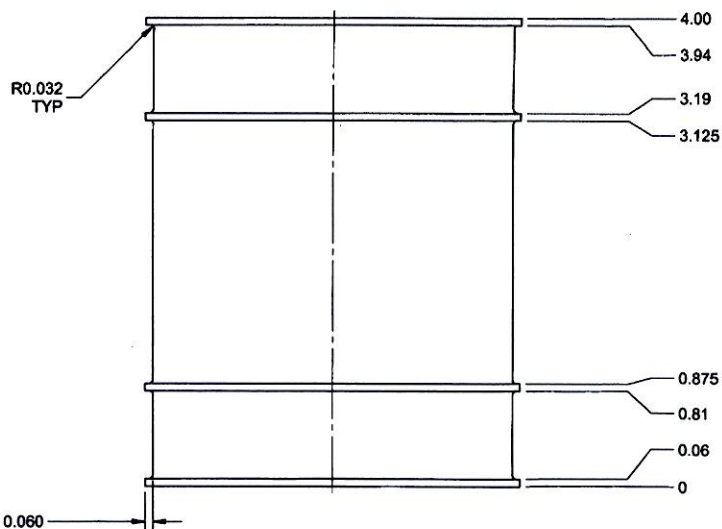
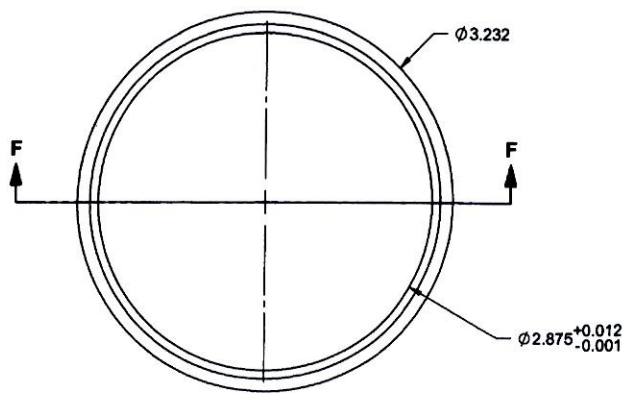
MAT013

7.725

m137043

7.725

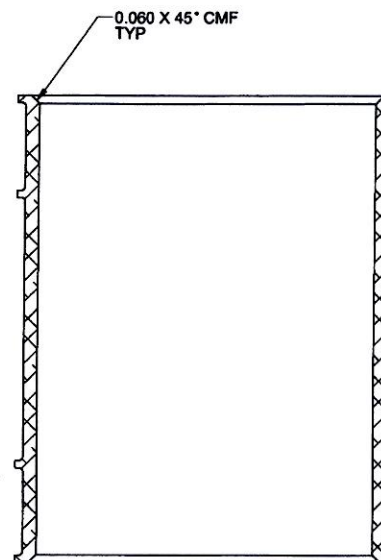
~~2.125~~ 2.125'



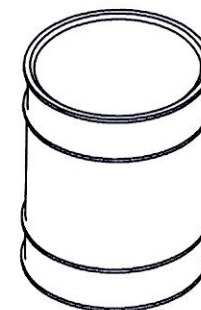
D5149-7TRN TURNING DETAIL

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221
REF DART SPEC. M6061T6R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.41 lbs



SECTION F-F



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 165329
ML5
170822

RELEASED
2015-11-04

APPROVED

DESIGN	DB	DART AEROSPACE LTD	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DB	DRAWING NO.	REV. D
MFG. APPR.	DD	D5149	SHEET 10 OF 11
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	STEP ASSEMBLY	NTS
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